## Work Order ID 107759

Page 1

10:15:52 AM					<b></b> . <b></b>				T-174			_
D2346 Spacer			Accept	*N	1900	<b>040</b>	100	)* s		1.71	S1* S2*	
10/01/13 : 10/01/13		• • •				D:						
Process Pla	an:	Date:	Tooling: SPC (Y/N):					R		n ''		
D	Operation Description		Set Up/ Run Hours		Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Rev	vision Nbr											
Rev	/ B											
he Small	Memo	•	0.00	0AS 1	13/1	0/01		lo	Ø	·	. ,	
	QC2- Inspect parts of  Memo	f machine FAI/FAIB	0.00	AS\ 40,	13/10	0/01		10	Ø			;
	QC8- Inspect parts - s	second check	0.00	J	ll13-10	-01		10	_Ø_			-
	D2346  Spacer 10/01/13 : 10/01/13  Process Pla QC:  D  Rev	Spacer  10/01/13 Start Qty: 10.0  10/01/13 Req'd Qty: 10.0  Process Plan: QC:  Operation Description Revision Nbr Rev B  Hardinge CNC LATH Memo Machine  QC2- Inspect parts of Memo	Spacer  10/01/13 Start Qty: 10.00 *10* : 10/01/13 Req'd Qty: 10.00 *10*  Process Plan: Date: QC: Date:  Operation Description  Revision Nbr Rev B  Hardinge CNC LATHE SMALL  Memo Machine as per folio FA198Deburr  QC2- Inspect parts off machine FAI/FAIB	Spacer  10/01/13 Start Qty: 10.00 *10* : 10/01/13 Req'd Qty: 10.00 *10*  Process Plan: Date: Tooling: QC: Date: SPC (Y/N):  Operation Set Up/ Run Hours  Revision Nbr Rev B  Hardinge CNC LATHE SMALL Memo Machine as per folio FA198Deburr  QC2- Inspect parts off machine FAI/FAIB 0.00  Memo 0.00	Spacer  10/01/13 Start Qty: 10.00 *10* : 10/01/13 Req'd Qty: 10.00 *10*  Process Plan: Date: Tooling: SPC (Y/N):  Date: SPC (Y/N):  Description Set Up/ Run Hours  Revision Nbr Rev B  Hardinge CNC LATHE SMALL Memo Machine as per folio FA198Deburr  QC2- Inspect parts off machine FA1/FA1B 0.00  QC8- Inspect parts - second check 0.00	Spacer	Spacer  10/01/13 Start Qty: 10.00 *10* Cust Item ID: 10/01/13 Req'd Qty: 10.00 *10* Customer:  Process Plan: Date: Tooling: Date: QC: Date: SPC (Y/N): Date:  Operation Set Up/ Run Hours  Revision Nbr Rev B  Hardinge CNC LATHE SMALL Memo Machine as per folio FA198Deburr  QC2- Inspect parts off machine FAI/FAIB  QC3- Inspect parts - second check  QC8- Inspect parts - second check	D2346	Spacer	Second	Spacer   Start   Start   Stop   Start   Stop   St	Spacer

Work Orde				*107	759*						Page 2
Item ID: Revision ID: Item Name:	D2346 Spacer			Accept	*N900	<u>040</u>	100	)*	Setup Sta	14.7	\1* \2*
Start Date: Required Date: Reference:	10/01/13 : 10/01/13	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item I Customer:	ID:					
Approvals:	Process P	lan:	Date:	Tooling:	D	ate:			Run Sta	"IN F	<b>?1</b> *
	QC:		Date:	<b>SPC (Y/N):</b>	<b>D</b>	ate:	Marketin and A. Johnson		Sto	*NF	₹2*
Sequence ID/ Work Center I	D	Operation Description Chemical Conversion Co.	at per QSI005 4.1	Set Up/ Run Hours 0.00	Tool ID		Plan Code	Accept Qty	Qty	Number 5	Insp. Stamp
*120* HandFinish Hand Finishing		Memo		0.00				10	H	13.80	

140

QC7-Inspect Chemical Conversion Coat

\*14**0**\*

Quality Control

Memo

\*150\* Packaging

Identify as per dwg & Stock Location (6x) 008

Memo (4x) Ship

0.00

10x 28 13-10-1

150

Packaging

Work Orde				*107	7759*	7,1477-341					Page 3	}
Revision ID:	D2346 Spacer			Accept	*N900	<b>040</b>	100	)* s	Setup St		 31* 32*	
Start Date: Required Date: Reference:	10/01/13 10/01/13		*10* *10*		Cust Item I Customer:	D:					 	
Approvals:	Process QC:	s Plan:	Date:	Tooling: SPC (Y/N):		ate:		F		ton	 २1* २2*	
Sequence ID/ Work Center II	)	Operation Description QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Rejec Num	Insp. Stamp	
*160* QC Quality Control		Memo	Work State Notate	0.00				M	15 L	13	-01 WK	

MF 10-0

October-01-13 10:15:52 AM

Work Order ID:

107759

Parent Item:

D2346

Parent Item Name:

Spacer

**Start Date:** 10/01/13

Required Date: 10/01/13

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP G02.03.05Re-format to machine in houseNG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.375W.035	035W	Purchased	No			100	f	213.1722	0.1042	1.0968421	OAS	` [	3/10/0
				Location		Loc Oty	<u>Lo</u>	c Code			40 %-x^		. , ,
				MAT014		213.1722							
				1126	552	105.1722			<u> </u>	<u> </u>			
				1244	191	108							

DART AEROSPACE LTD	Work Order:	101159
Description: Spacer	Part Number:	D2346
Inspection Dwg: D2346 Rev: B		Page 1 of 1

	FIR	ST ARTICLE	INSPEC	LION CHE	ECKLIST		
		X First Ar	ticle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Con	nments
1.25	+/-0.030	1,275	/		VERN	P40-12	-
				_			
		·					
	ίΩΛς.						
	1.40 9-89						<b>N</b> 1/2
Measured by:		Audited by		<i>Y</i>	Prototype A		N/A
Date:	13/10/01	Date	e: 13-10	-01		Date:	N/A
Rev Date	Change				F	levised by	Approved

Rev	Date	Change	Revised by	Approved
Α	08.11.27	New Issue	KJ/EC	N
			[7]	لسالجوا





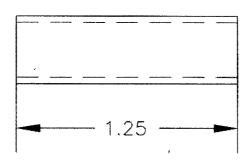
DESIGN BW	DRAWN BY	1	AEROSPACE LTD		<b>tau</b>
CHECKED	APPROVED APPROVED	DRAWING NO. D2346	SHEET	REV. 1 OF	
DATE		TITLE		SCA	LE
 99.12.15	5	SPACER		2	2:1
Α	95.01.05	NEW ISSUE			
В	99.12.15	ADD FINISHIN	G	***************************************	



**UNDER REVIEW** 

31.63.15 CP

DESIGN OK, BUT CHECK WITH TB BEFORE MANUFACTURE



WW 107759

MATERIAL: 6061-T6 (WW-T-700/6) 0.375 DIA  $\times$  0.035 WALL FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED BREAK SHARP EDGES 0.010 TO 0.020